

22 Sept

Work Order ID 166367

166367

Page 1

Monday, September 18, 2017 10:22:35 AM

Item ID: D407-802-019 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Baggage Door Opener Composite Door
 Start Date: 9/19/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/22/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: SEP 18 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-1	A								
IIN-D407-802-2	A								
IIN-D407-802-3	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D407-802-019 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-89

1 SEP 19 2017 nl

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 166367

Monday, September 18, 2017 10:22:35 AM

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Page 2

Item ID: D407-802-019**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Baggage Door Opener Composite Door**Start Date:** 9/19/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/22/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.03							
						DAS 27 9-89 SEP 19 2017			
120 *120* Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo Identify and pack for shipping as per PPPD407-802-019 Location: FG021	0.00 0.00							
						DAS 27 9-89 SEP 19 2017			
130 *130* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							
									17/9/21



SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

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Work Order ID: 166367

166367

Parent Item: D407-802-019

D407-802-019

Parent Item Name: Baggage Door Opener Composite Door

Start Date: 9/19/2017

Required Date: 9/22/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.03 as per dwg rev.A DD verf:EC
PER ECN12-624 DD verf:EC

IPP Rev:B
IPP Rev:C 12.07.30 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-19		Manufactured	No			105	Each	12.0000	1	1			
D3552-19 Door Prop													

DAS
27
9-89

Location	Loc Qty	Loc Code
ST363	12	
100867	4	
126844	1	
127455	6	
88102	1	

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9-89

D4109-041		Manufactured	No			105	Each	0.0000	1	1			
D4109-041 Doubler Assembly, Bulkhead													

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9-89

B166368 x 1

SEP 19 2017

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D4109-043		Manufactured	No			105	Each	1.0000	1	1			
D4109-043 Doubler Assembly													

DAS
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9-89

Location	Loc Qty	Loc Code
ST077	1	
104229	1	

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DAS
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80-004-2-6		Purchased	No			105	Each	433.0000	3	3			
80-004-2-6 Insert													

DAS
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Location	Loc Qty	Loc Code
ST584	433	
124720	433	

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DAS
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9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

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Work Order ID: 166367

166367

Parent Item: D407-802-019

D407-802-019

Parent Item Name: Baggage Door Opener Composite Door

Start Date: 9/19/2017

Required Date: 9/22/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-05

Purchased

No

105

Each

62.0000

4

4

MS27039C1-05

SCREW

DAS
27
9-89

**

SEP 19 2017

DAS
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9-89

Location

Loc Qty

Loc Code

ST277

62

107242

62

4

MS27039C1-06

Purchased

No

105

Each

122.0000

3

3

MS27039C1-06

Screw (601.2459)

DAS
27
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**

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DAS
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9-89

Location

Loc Qty

Loc Code

ST277

122

123525

122

3

NAS1149C0363R

Purchased

No

105

Each

257.0000

7

7

NAS1149C0363R

Washer

DAS
27
9-89

**

SEP 19 2017

DAS
28
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Location

Loc Qty

Loc Code

FP001

55

m133077

55

GA

6

m133077

6

ST266

196

m137495

20

m138326

176

7

NAS1836-3-08M

Purchased

No

105

Each

14.0000

4

4

NAS1836-3-08M

Insert

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**

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DAS
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Location

Loc Qty

Loc Code

ST548

14

120422

14

4

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DQA: _____ Date: _____



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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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								OTHER :	

5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Item ID:	D407-802-019	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Baggage Door Opener Composite Door					
Start Date:	9/19/2017	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	9/22/2017	Req'd Qty:	1.00	*1*	Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
		SEP 18 2017				*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-1	A								
IIN-D407-802-2	A								
IIN-D407-802-3	A								
100	Document Control	0.00							DAS
100	DOCUMENT CONTROL								5
DC	Memo	0.00							9-89
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D407-802-019 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

SEP 19 2017

SEP 19 2017

DAS
28
9-89



Transport Canada Transports Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH10-44

Issue No.: 1

Approval Date: November 25, 2010

Issue Date: November 25, 2010

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

BELL 206, 206A, 206A-1, 206B, 206B-1, 206L, 206L-1, 206L-3, 206L-4, 407

Canadian Type Certificate or Equivalent:

H-92

Description of Type Design Change:

Automatic Door Opener Kits (Cabin Doors and Baggage Door)

**Installation/Operating Data,
Required Equipment and Limitations:**

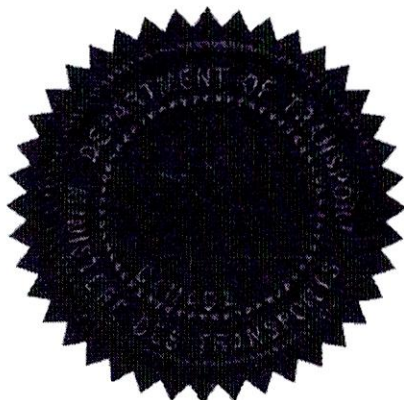
Door Opener Kits must be manufactured in accordance with the Manufacturing Data referenced in Transport Canada Civil Aviation (TCCA) approved DART Aerospace Master Document List MDL-D407-802, Revision A, dated November 17, 2010, or later TCCA approved revision.

Installation of Door Opener Kits must be in accordance with TCCA approved DART Aerospace Installation Instructions IIN-D407-802, Revision A dated October 13, 2010, or later TCCA approved revisions.

Maintenance of installed Door Opener Kits must be in accordance with TCCA accepted DART Aerospace ICA-D407-802 Revision 0, dated October 13, 2010 or later TCCA accepted revisions.

The Certification Basis for affected areas associated with this design change is FAR Part 27 at amendment 27-45.

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.

D. Hoepfner
For Minister of Transport

Canada